

Work Order ID 67800



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Wednesday, March 30, 2011 1:00:27 PM

Item ID:	D3144-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	3/30/2011	Start Qty: 4.00		Cust Item ID:		
Required Date:	4/8/2011	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	<i>ME</i>	Date:	11-03-30	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3144	Rev C								
100	PURCHASING	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
2024.032	1-Cut as per Dwg								
	Dwg Rev: <i>C</i>								
	Prog Rev: <i>C</i>								
	2-Deburr if necessary								
	Deburr <i>(4X) M-L 11/04/04</i>								
110	QC2-Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

1311-4-1

(4)

1311-4-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3144-3 PAR #: N/A Fault Category: Small FAB NCR: Yes No DQA: 11 Date: 11.04.25
 Resolution: use as in Disposition: use as in QA: N/C Closed: OK Date: 11/04/25

NCR: 67800		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.4.7	120	Parts found to measure 0.440" instead of 0.430" R.C. Process	11.04.07 OS1042	PART IS ACCEPTABLE	a/u	11.04.07 OS1042	11.04.07 OS1042	11.04.07

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 67800

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Wednesday, March 30, 2011 1:00:27 PM

Item ID: D3144-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 3/30/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 0 All n104/18

170

Identify as per dwg & Stock Location: ZY1A

0.00



Packaging

Memo

0.00

Packaging

11/14/19 SP RD

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/14/19 JF

11/14/19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 67800



Parent Item: D3144-3



Parent Item Name: Doubler



Start Date: 3/30/2011

Required Date: 4/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.03.30 now made in house DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032  2024-T3 .032 sheet		Purchased	No			100	sf	58.9000	0.212	0.892632			
										B11-4-1			

Location

Loc Qty

Loc Code

MAT22

58.9

105555

0.4

111699

0.5

113189

58

10555

(4)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

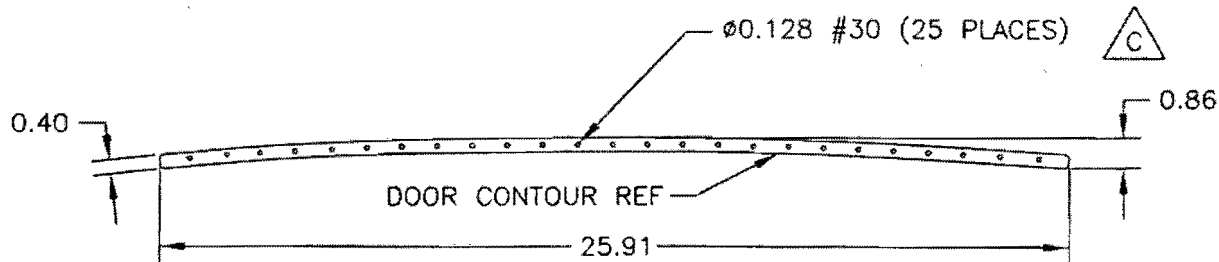
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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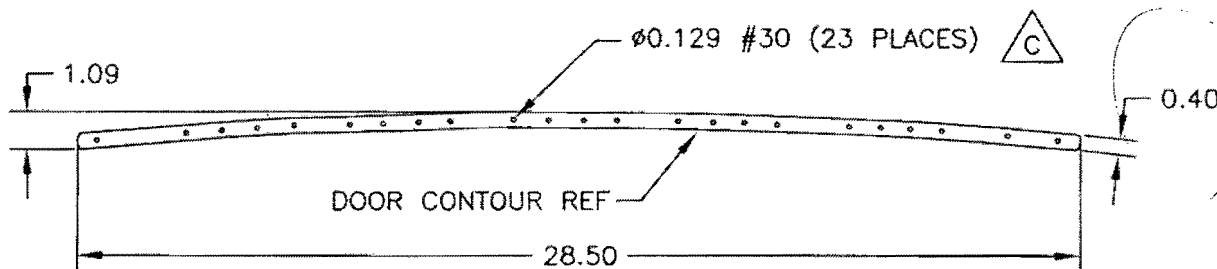
DART

RELEASED

05.11.14



D3144-1 DOUBLER (FOR D412-694-03)
REPLACES PREMIER P/N B30-23000-191



D3144-3 DOUBLER (FOR D412-694-01)
REPLACES PREMIER P/N B30-23000-193

67800

D3144-1/-3 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C1.DWG"

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.10.19	TITLE	D3144	REV. C
			DOUBLER	SHEET 1 OF 9
A	02.04.22	NEW ISSUE		SCALE
B	04.09.17	ADDED D3144-105/-107/-109/-111/-115/-121/-123; MODIFY D3144-1		1:5
C	05.10.19	ADD D3144-15; Ø0.129 WAS Ø0.098		

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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